



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3193-041
Job Sheet 208622



Part No: D3193-041

Job Qty: 1 pcs

Part Name: Support Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/27/20

Job Tracking No:

Due Date: 4/10/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP Rev:A New Issue 05-11-05 JLM IPP Rev:B Change Rivet Lengh 07-03-19 JLM IPP Rev: C
Step 13 added 08.12.18 KJ Verified by:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	1 pcs		4/9/20	0.00	0.01	Bandsaw - 1		20/03/20
110	HAAS 4 Axis - B4B	1 pcs		4/9/20	1.00	2.14	HAAS 1 - B4B NV5000-1-B4B		20/03/20
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	1 pcs		4/9/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

DAS
86
9-89

20/03/20



Container No: S266954



Part: D3193-041

Job No: 208622

Serial No/Batch: S266954

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
CANADA
TEL: 1-613-632-5200
Email: sales@dart.ca
www.dart.ca

Date: 03/27/20

					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
130 QC 8	1	4/9/20	0.00 0.00		QC 8 - 12	
	pcs				QC 8 - 14	20/03/30
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
140 Handfinish - 1-1 Chemical-B4B	1	4/9/20	0.00 0.08		Handfinish - 1 - 1 - B4B	20/03/30
	pcs				Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	

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			Handfinish - 1 - 21 - B4B		
			Handfinish - 1 - 22 - B4B		
150 Powdercoat - 1 White GI(A)- B4B 11235540	1 pcs	4/9/20	0.00 0.06	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				START: 8:15 OJT: 320 PUNCH 18:45	
160 QC 3	1 pcs	4/9/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
170 Small Fab - 2 - B4B	1 pcs	4/10/20	0.00 0.15	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
180 QC 5	1 pcs	4/10/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
Plex 3/27/20 8:57 AM dart.lacelle:Inde					

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				QC 5 - 61	
				QC 5 - 81	
190 Packaging 3-1 - Stock - B4B	1 pcs	4/10/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	DAS
				Packaging 3 - 23 - B4B	84
				Packaging 3 - 24 - B4B	9-89
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
200 QC 21 - SA	1 pcs	4/10/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

ST334

APR 09 2020

Part Op 100 - (Bandsaw) Cut blanks: 3.500" x 2.500" x 6.00" long Bar
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA374 and Dwg D3193 Identify as D3193-1 2-Debur and Tumble
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 160 - QC3- Inspect Part Finish
 170 - (Small Fab) Assemble D3193-041 as per Dwg D3193
 180 - QC5- Inspect part completeness to step on W/O
 190 - Identify as per dwg & Stock Location: _____
 200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.750X03.750	6061-T6 Bar 2.75 X 3.75 using mat'l	.4910 ft (.491 ea)	100-Bandsaw - 1	
MS20426AD3-7	M6061T6B3.000X4.000 Rivet	8 Ea (8 ea)	170-Small Fab - 2 - B4B	S266878
MS21073L4	Nutplate	4 Ea (4 ea)	170-Small Fab - 2 - B4B	S268551
				S2667
				S267763

ST312
GA012

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B2.750X03.750	0	0	0
170-Small Fab - 2 - B4B	MS20426AD3-7	8	0	0
	MS21073L4	4	0	0

Part Specifications
Specifications could not be found.

Plex 3/27/20 8:57 AM dart.lacelle.linda

DART AEROSPACE LTD		Work Order:	208622
Description: Support Bracket		Part Number:	D3193-1
Inspection Dwg: D3193 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.435	+/-0.010	3.435	✓		B18017739	VER.
2.012	+/-0.010	2.012	✓		"	—
1.200	+/-0.010	1.205	✓		"	—
2.006	+/-0.010	2.007	✓		"	—
R0.125	+/-0.010	R.125	✓		R-G	REF.
2.435	+/-0.005	2.436	✓		B18017739	VER.
0.281	+/-0.005	.281	✓		"	—
0.264	+/-0.010	.265	✓		"	—
5.878	+/-0.010	5.878	✓		"	—
4.878	+/-0.005	4.879	✓		"	—
2.550	+/-0.010	2.550	✓		"	—
15°	+/-0.5°	14.9°	✓		A-G	CNC-17
0.260	+/-0.010	.261	✓		B18017739	VER.
R0.05 R0.50	+/-0.030	R.50	✓		RG	REF.
Ø0.266	+0.006/-0.001	.265	✓		GP	REF.
Ø0.098	+0.004/-0.001	.098	✓		GP	REF.
Ø0.180 x 100°	+0.005/-0.001	.181	✓		B18017739	VER.
0.850	+/-0.010	.846	✓		"	—
R0.125	+/-0.010	R.125	✓		R-G	REF.
0.255	+/-0.010	.255	✓		B18017739	VER.
2.812	+/-0.010	2.813	✓		"	—

Measured by: ALA	Audited by: [Signature]	Prototype Approval:	N/A
Date: 20/03/28	Date: 20/03/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3193-041	KJ/DD	[Signature]
B	09.05.04	R0.50 was R0.050	KJ/DD	[Signature]